

Work Order ID 152869

Tuesday, November 08, 2016 8:29:24 AM

152869

Page 1

Item ID: D3204-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Release Pedal Assembly**Start Date:** 10/24/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 11/7/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:**

DAS

21

Date: NOV 08 2016**Tooling:****Date:****QC:**

9-89

Date:**SPC (Y/N):****Date:****Run Start *NR1*****Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								

100

0.00

100

Large Fab

Large Fab

Memo

0.26

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

2 @ 16-12-2

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

② 16-12-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120 QC Quality Control	Memo	0.01				<u>②</u>	<u>16-12-06</u>	<u>80</u>	
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	0.05				<u>(x2)</u>	<u>16-12-07</u>	<u>2016/12/07</u>	<u>BEB</u>
140	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
140 Powdercoat Powder Coating	<u>17134858</u> Memo ***Cover holes for bushing*** START TIME: <u>11:05</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>11:35</u>	0.02				<u>2</u>	<u>16-12-07</u>	<u>34</u>	<u>3-88</u>

DQA: _____ Date: _____



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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 10/24/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 11/7/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

150

2

DAS
38
9-89
DEC 07 7016

160

2x

16/12/07

170

2

DAS
38
9-89
DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

DEC 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Picklist Print

Tuesday, November 08, 2016 8:29:30 AM

Page 1

Work Order ID: 152869

152869

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 10/24/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3204-1

Manufactured

No

100

Each

10.0000

1

2

D3204-1

**

Tube

Location

Loc Qty

Loc Code

WA002

10

144635

10

D3204-11

Manufactured

No

100

Each

2.0000

1

2

D3204-11

**

Plate

Location

Loc Qty

Loc Code

WA002

2

142724

2

D3204-13

Manufactured

No

100

Each

8.0000

2

4

D3204-13

**

Gusset

Location

Loc Qty

Loc Code

WA002

8

148611

8

D3204-3

Manufactured

No

100

Each

11.0000

1

2

D3204-3

**

Arm

Location

Loc Qty

Loc Code

WA001

1

145631

1

WA002

10

150617

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 10/24/2016

Required Date: 11/7/2016

Start Qty: 2.00

Required Qty: 2.00

D3204-5

Manufactured No

100 Each

4.0000

1 2

D3204-5

Arm

**

C2 16-12-1

Location

Loc Qty

Loc Code

WA002

4

148254

4

2

D3204-9

Manufactured No

100 Each

4.0000

1 2

D3204-9

Pedal

**

C2 16-12-1

Location

Loc Qty

Loc Code

WA002

4

144594

4

2

D3204-7

Manufactured No

160 Each

13.0000

2 4

D3204-7

Bushing

**

16-12-07 **DAS 36 9-89**

Location

Loc Qty

Loc Code

GA

13

147440

13

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

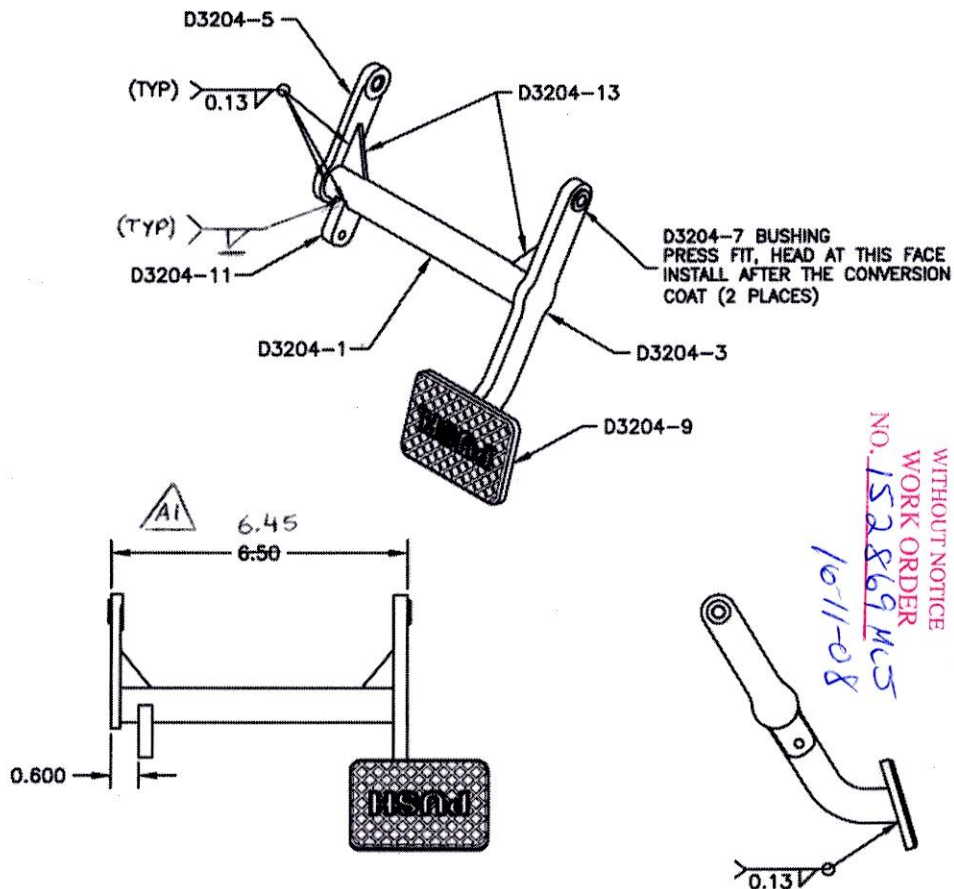
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OTHER :																																																															

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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